

Date: Wednesday, 09/07/2008 1:29:41 PM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 40402
Estimate Number : 10858
P.O. Number :
This Issue : 09/07/2008 S.O. No. :
Prsht Rev. : NC
First Issue : 09/07/2008 Type : SMALL /MED FAB
Previous Run : 34708
Written By :
Checked & Approved By :
Comment : Est Rev:A New Issue 05-11-22 JLM
Est Rev:B Now on Waterjet 08-05-14 JLM Verified By:DD

Drawing Name : RING
Part Number : D34075
Drawing Number : D3407 REV D
Project Number : N/A
Drawing Revision : D
Material :
Due Date : 16/07/2008 Qty: 40 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M174B0250X4000 17-4 SS Bar 1/4" X 4"



Comment: Qty.: 0.2799 Ft(s)/Unit Total: 11.1972 Ft(s)
Material: 17-4ph SS 4.00" X .250" THK
Identify for D3407-5
Batch: 107951 ml 08 07 10

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
1-Cut as per Dwg D3407
Dwg Rev: D
Prog Rev: D

2-Break edges on grinder as per Dwg D3407 ml 08 07 10

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK

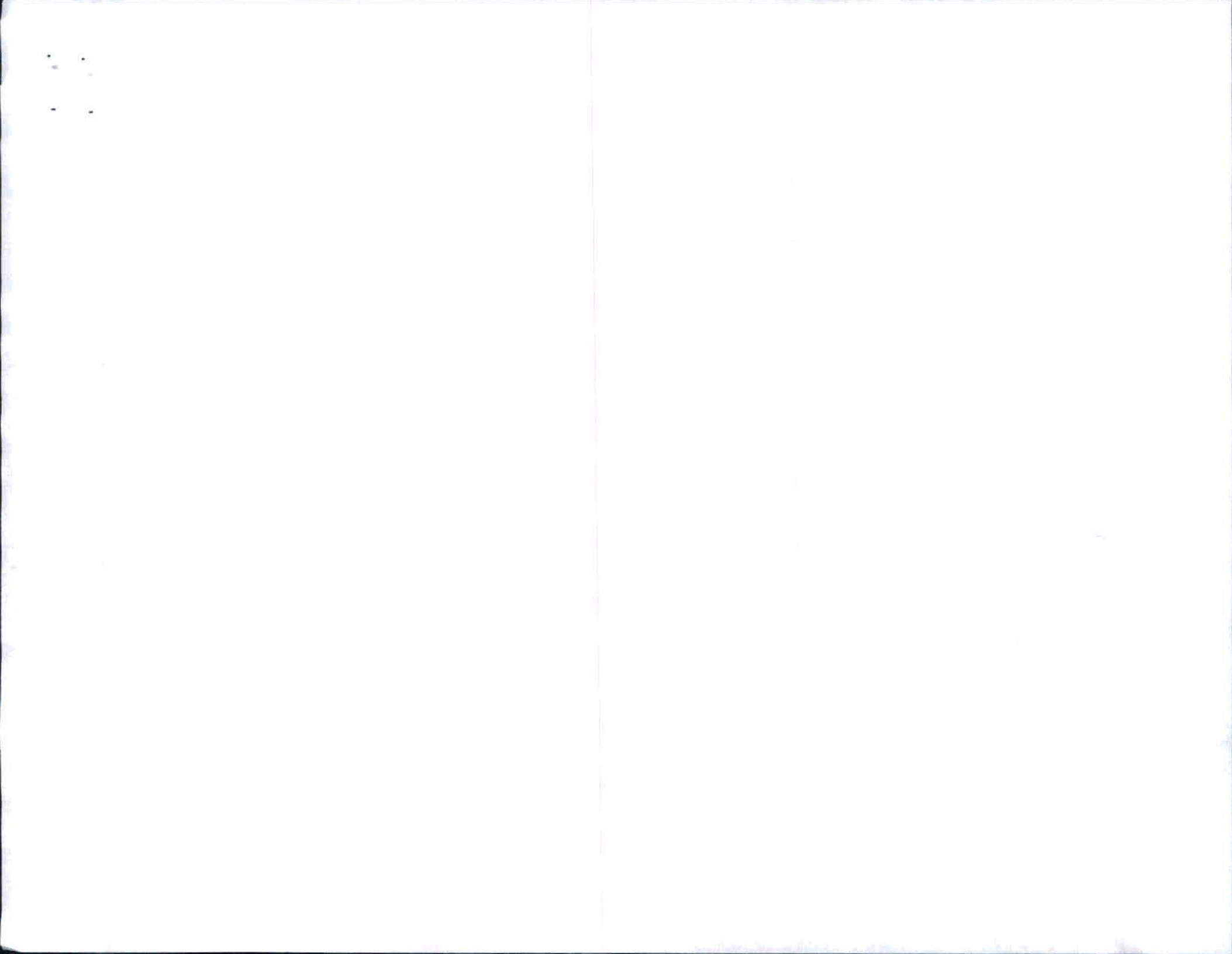


Comment: SECOND CHECK

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location:



Date: Wednesday, 09/07/2008 1:29:41 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RING

Job Number: 40402

Part Number: D34075

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/18 *[Signature]*

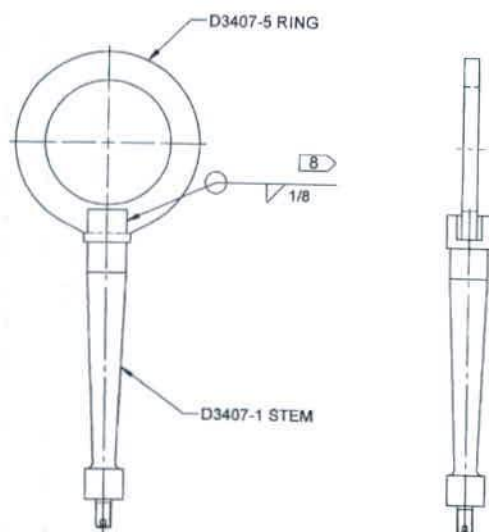
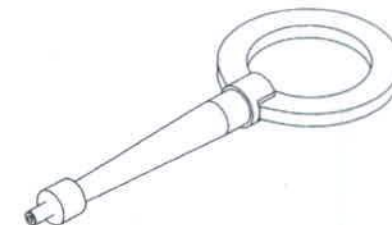
Job Completion



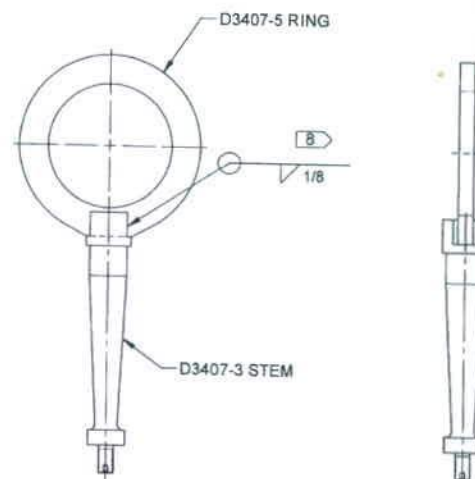
u 08/07/18



| QTY -041 | QTY -043 | PART NUMBER | DESCRIPTION |
|-------------|-------------|-------------|-------------|
| X | | D3407-041 | TOW RING |
| | X | D3407-043 | TOW RING |
| 1 | | D3407-1 | STEM |
| | 1 | D3407-3 | STEM |
| 1 | 1 | D3407-5 | RING |



D3407-041 TOW RING



D3407-043 TOW RING

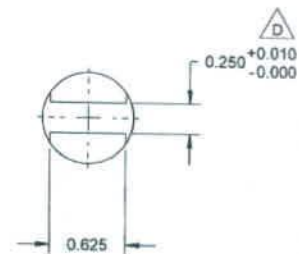
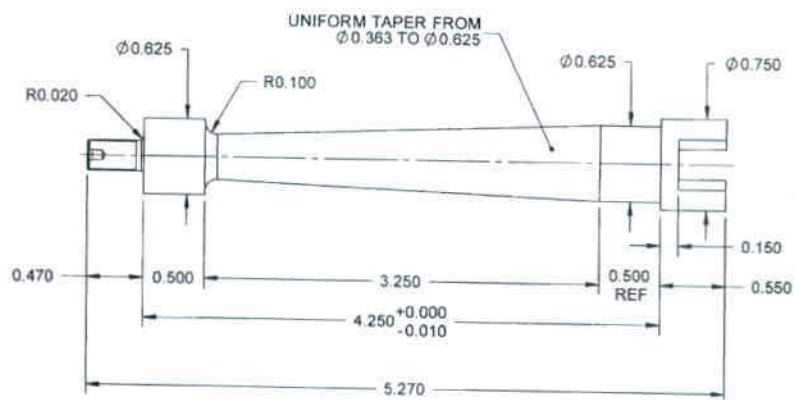
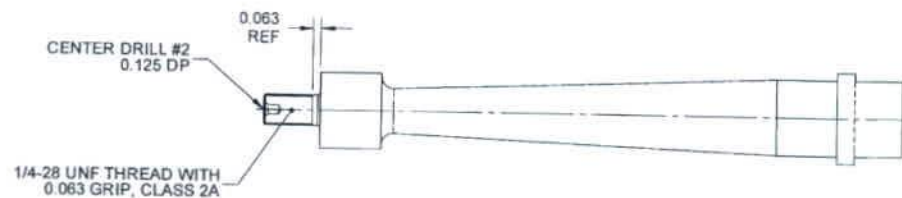
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3 (EXCEPT THREADS)
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3407-041 - 0.60 lbs, D3407-043 - 0.53 lbs
- 8) WELD PER DART QSI 004 ON ALL EDGES BETWEEN STEM AND RING

RELEASED
05-13-14

| | | | |
|------------|---|--------------|----------|
| REV. | DESCRIPTION | BY | DATE |
| D | D3407-1/3 SLOT WAS ROUND NOW FLAT FOR ASSEMBLY WITH D3407-5 (ZN C2-2, C2-3); D3407-5 WAS ROUND NOW FLAT ON ONE END FOR ASSEMBLY WITH D3407-1/3 (ZN B6-4); REASON: PRODUCTION FACILITY | PH | 08.04.07 |
| C | -1/3 LONGER FOR FIT W/WASHER | CP | 05.09.09 |
| B | UPDATE DIAMETER, THREAD CLASS ADDED | CP | 05.06.17 |
| A | NEW ISSUE | CP | 05.03.16 |
| DESIGN | DART AEROSPACE USA, INC. PORT HADLOCK, WA | | |
| DRAWN | DRAWING NO. D3407 | REV. D | |
| CHECKED | TITLE TOW RING | SHEET 1 OF 4 | |
| MFG. APPR. | SCALE NTS | | |
| APPROVED | DATE 08.04.07 | | |
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D3407-1 STEM

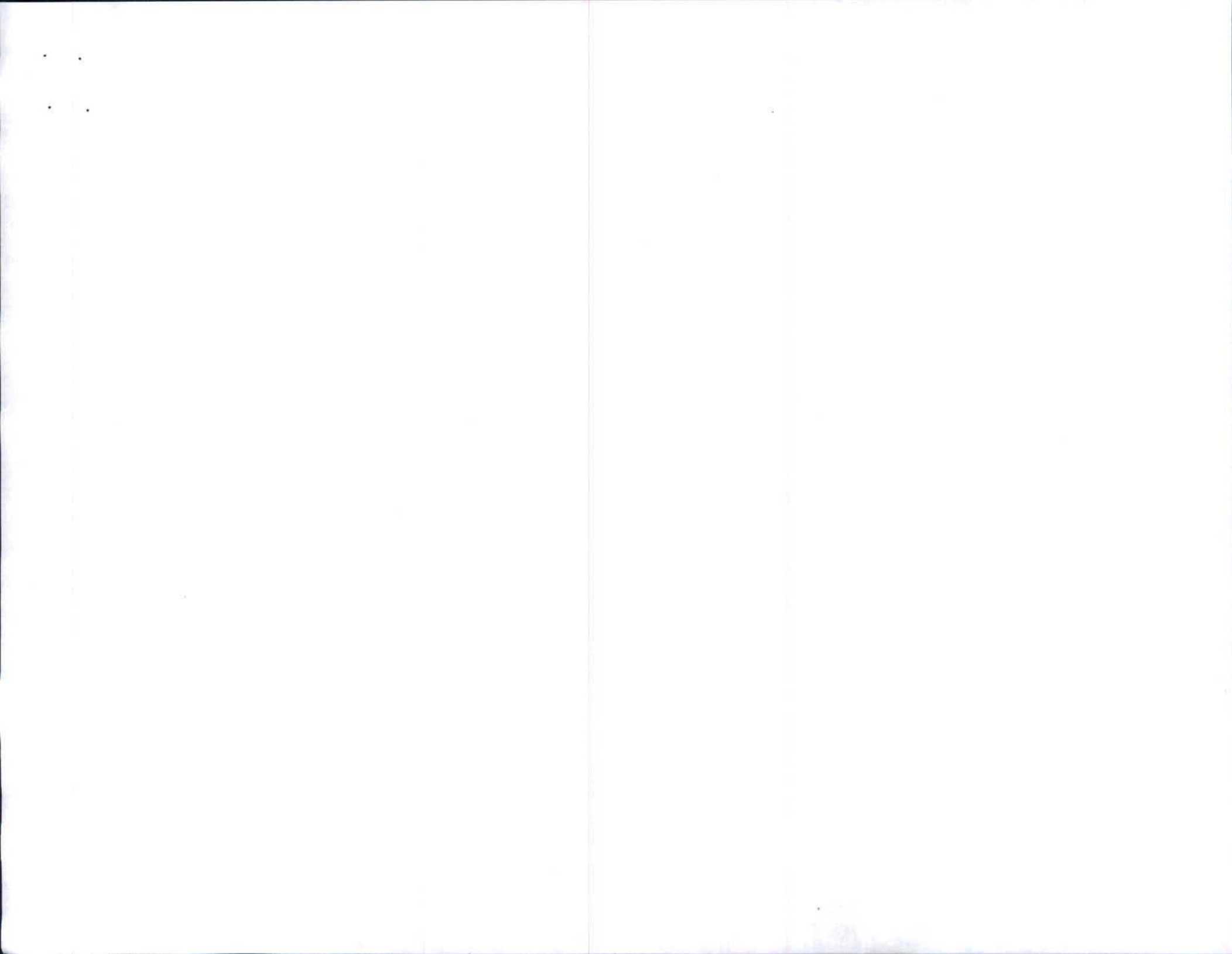
RELEASED
08-06-12

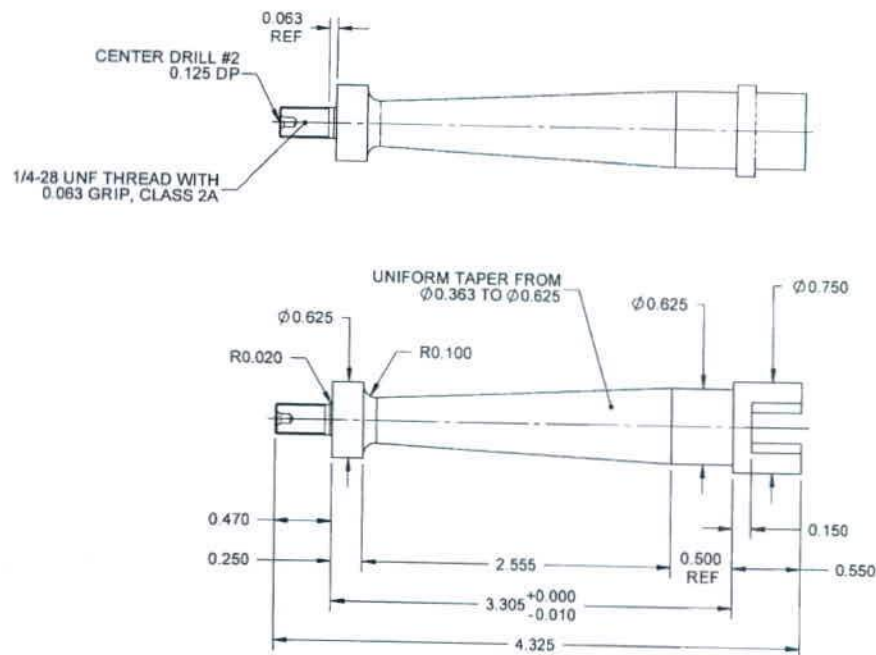
NOTES:

- 1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.33 lbs

| | | | |
|------------|----------|--|--------------|
| DESIGN | | DART AEROSPACE USA, INC. | |
| DRAWN | | PORT HADLOCK, WA | |
| CHECKED | | DRAWING NO. | REV. D |
| MFG. APPR. | | D3407 | SHEET 2 OF 4 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | TOW RING | NTS |
| DATE | 08.04.07 | COPYRIGHT © 2005 BY DART AEROSPACE USA, INC. | |

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D3407-3 STEM

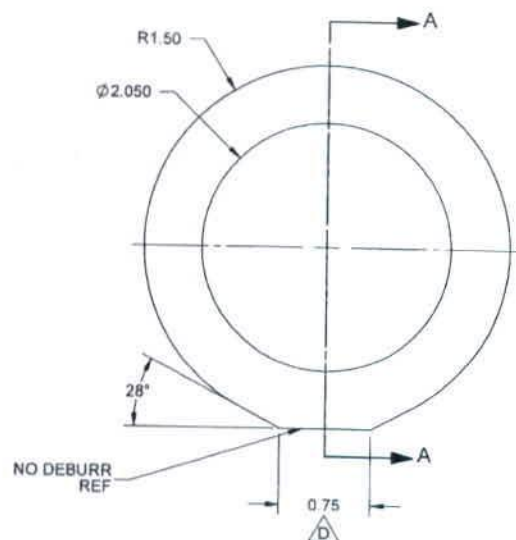
- NOTES:
- 1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.27 lbs

| | | | |
|------------|----------|--|--------------|
| DESIGN | DP | DART AEROSPACE USA, INC. | |
| DRAWN | PH | PORT HADLOCK, WA | |
| CHECKED | | DRAWING NO. | REV. D |
| MFG. APPR. | | D3407 | SHEET 3 OF 4 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | TOW RING | NTS |
| DATE | 08.04.07 | COPYRIGHT © 2005 BY DART AEROSPACE USA, INC. | |

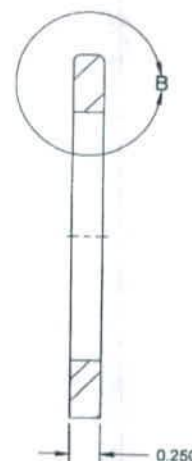
RELEASED
08-05-13 14

Wls 44422

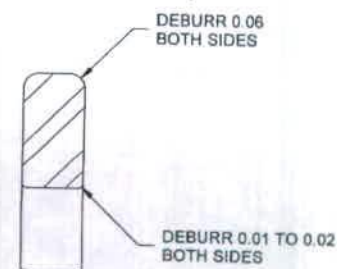
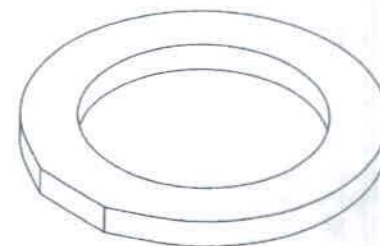




D3407-5 RING



SECTION A-A



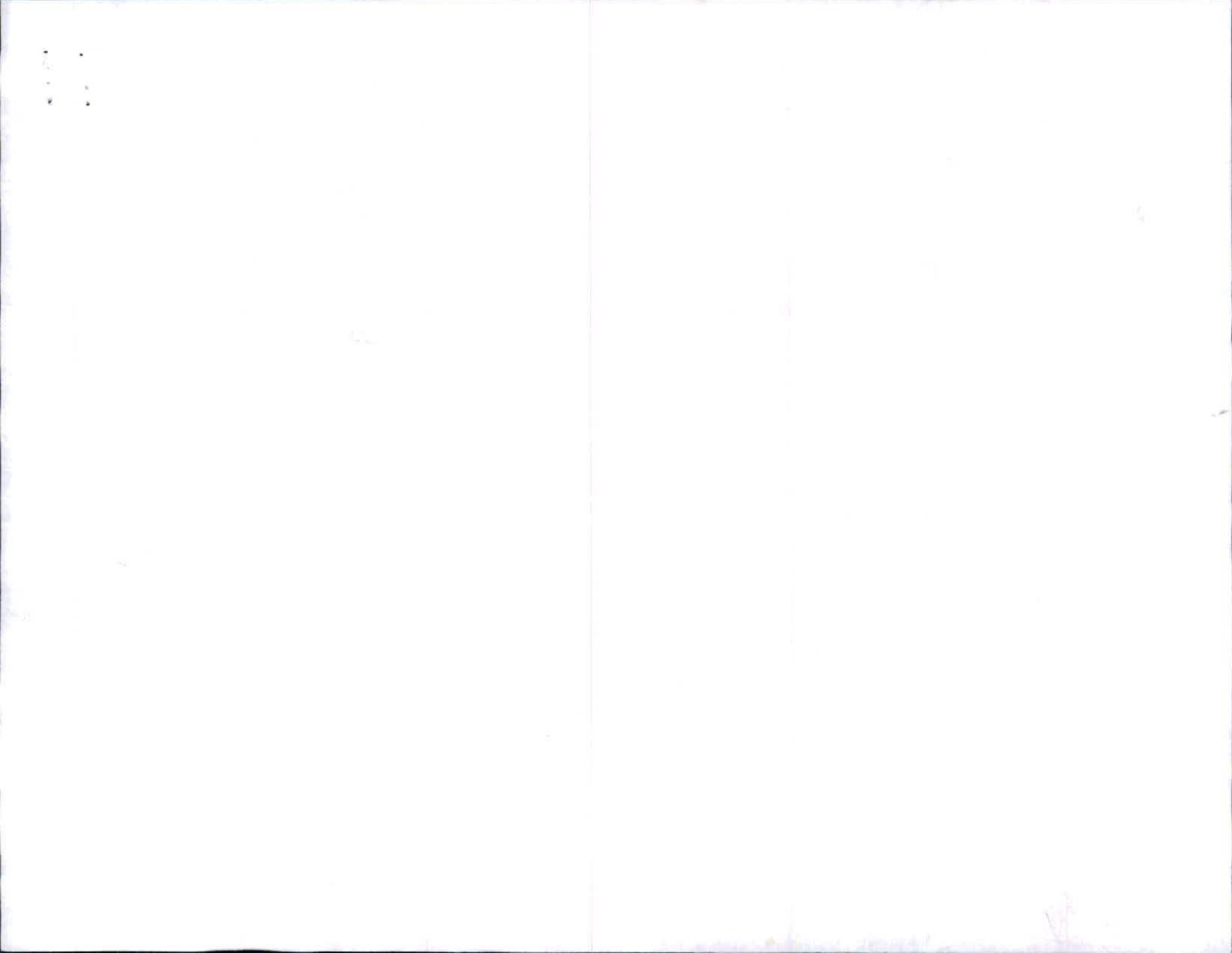
**DETAIL B
SCALE 2X**

RELEASED
08-05-13

- NOTES:**
- 1) MATERIAL: 17-4 PH SS BAR PER AMS 5604/5643 (REF. DART SPEC M17-4-B)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.27 lbs

W1040402

| | | | |
|------------|----------|---|--------------|
| DESIGN | 90 | DART AEROSPACE USA, INC. | |
| DRAWN | 104 | PORT HADLOCK, WA | |
| CHECKED | | DRAWING NO. | REV. D |
| MFG. APPR. | | D3407 | SHEET 4 OF 4 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | TOW RING | NTS |
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| | | | |
|----------------------|--------|--------------|---------|
| DART AEROSPACE LTD | | Work Order: | 40402 |
| Description: Ring | | Part Number: | D3407-5 |
| Inspection Dwg: 3407 | Rev: D | Page 1 of 1 | |

FIRST ARTICLE INSPECTION CHECKLIST

| X | First Article | | Prototype |
|---|---------------|--|-----------|
|---|---------------|--|-----------|

[illegible]

| | | | | | |
|--------------|----------|-------------|----------|---------------------|----|
| Measured by: | ml.ml | Audited by: | | Prototype Approval: | n/ |
| Date: | 08.07.10 | Date: | 08.07.10 | Date: | n/ |

| Rev | Date | Change | Revised by | Approved |
|-----|------|-----------|------------|----------|
| A | | New Issue | KJ/JLM | |

